

Date: Wednesday, 30/07/2008 11:12:20 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SHORT T-HANDLE ASSY		
Job Number	: 40816			Part Number	: PB674300163		
Estimate Number	: 13529			Drawing Number	: B6743001 P.15		
P.O. Number	:			Project Number	: N/A		
This Issue	30/07/2008	S.O. No.	:	Drawing Revision	: B1		
Prshrt Rev.	: NC			Material	:		
First Issue	:/	Type	LARGE FAB ASSY	Due Date	: 06/08/2008		
Previous Run	:			Qty:	:		
Written By	:			Um:	Each		
Checked & Approved By	: MF 08-08-30						
Comment	: Est Rev:A 08-07-29 new issue DD verified by:ec						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	Barcode	Signature	Date	Batch
1.0	PB6743001131	Tube End Cap			08.07.08	3
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)				
		Tube End Cap				
		batch: 3400220				
2.0	PB6743001129	Tube Handle			08.07.08	3
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)				
		Tube Handle				
		batch: m10531				
3.0	PB6743001127	Handle Arm			08.07.08	3
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)				
		Handle Arm				
		batch: m10531				
4.0	PB6743001157	Tube			08.07.08	3
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)				
		Tube				
		batch: m10531				
5.0	CR321342	Cherry Rivet			08.08.12	3
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)				
		Cherry Rivet				
		batch: 162569				

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 40816

Part Number: PB674300163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg

16 08-07-08

3

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

16 08-08-12 (3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16 08-08-12 (3)

9.0

POWDER COATING

POWDER COATING



M102316



(3X)

Comment: POWDER COATING

\*\*\*\*mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat\*\*\*\*

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

3:30

OVEN TEMPERATURE:

320

FINISH TIME:

4:00

16 08/08/12

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ML



(3X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-13

11.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

SPRING SLOTTED PIN

batch:

17830

16 08-08-26

3

Date: Wednesday, 30/07/2008 11:12:21 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 40816

Part Number: PB674300163

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 PB6743001133

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

batch: 323994

JK 08-08-26 3

13.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble by drilling thru both -157 and -133 as per dwg

2- install spring slotted pin as per dwg

JK 08-08-26 3

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/26 (x3)

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

39952

16.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26 (x3)

Job Completion



JK 08-08-26

